



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4037-1
Job Sheet 187125



Part No: D4037-1

Job Qty: 2 ea

Part Name: Aft Crossbeam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP REV:B AS PER REV B 10-04-19
JLM VERIFIED BY:EC IPP REV C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV:D AS PER
ECN 11-554 11-05-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		12/14/18	0.00	1.79	Waterjet - Flow		Dec 18/12/17
110	CNC Vertical Machining	2 pcs		12/14/18	0.00	7.41	HAAS1-4		Dec 19-01-13
120	QC	2 pcs		12/14/18	0.00	0.00	QC2 Machining-2		Dec 19-01-13
130	QC	2 pcs		12/14/18	0.00	0.00	QC8 Machining-2		Dec 19/01/14
140	HandFinish	2 pcs		12/14/18	0.00	0.38	HandFinish1		Dec 19/01/14
150	Powdercoat	2 pcs		12/14/18	0.00	0.40	Powdercoat1		JAN 15 2019 6:8
160	QC	2 pcs		12/14/18	0.00	0.00	QC3		9-89
170	Packaging	2 pcs		12/14/18	0.00	0.00	Packaging3-2		9-89
180	QC21-SA	2 Ea		12/14/18	0.00	0.00	QC21		JAN 15 2019

Part Op 100 - Cut blank as per file D4037-1_BLANK
Descriptions: 110 - MACHINE AS PER FOLI FA877 AND DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X16.000	6061-T6 Bar 1.00 X 16.00	7.8000 ft (3.9 ea)	100-Waterjet - Flow - 1	5136486

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B1.000X16.000	8	0	0

Part Specifications

Specifications could not be found.

Plex 11/28/18 8:37 AM Dart.lajeunesse.marie

P.T.O.

DART AEROSPACE LTD		Work Order:	187125
Description: Aft Crossbeam		Part Number:	D4037-1
Inspection Dwg: D4037 Rev: E		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.530	+/-0.010	0.522	✓		G-P/Mic	ref / GA-03
0.25	+/-0.030	0.254	✓		Deep throat Mic	118-120
2.00	+/-0.030	2.003	✓		T-6/Mic	ref / GA-02
2.75	+/-0.030	2.750	✓		Vern	GA-13
1.00	+/-0.030	1.025	✓		"	"
R0.032	+/-0.010	R0.032	✓		R-G	ref.
42.87	+/-0.030	42.875	✓		Tape	ref.
1.38	+/-0.030	1.376	✓		Vern	GA-13
1.750	+/-0.010	1.750	✓		"	"
2.125	+/-0.010	2.125	✓		"	"
2.250	+/-0.010	2.248	✓		"	"
0.875	+/-0.010	0.875	✓		"	"
0.875	+/-0.010	0.875	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.125	+/-0.010	1.125	✓		"	"
0.86	+/-0.030	0.856	✓		"	"
1.38	+/-0.030	1.377	✓		"	"
8.04	+/-0.030	8.042	✓		"	"
5.29	+/-0.030	5.297	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.315	✓		"	"
Ø0.391	+0.006/-0.001	Ø0.391	✓		"	"
0.38	+/-0.030	0.375	✓		"	-03
7.75	+/-0.030	7.750	✓		"	-13
R0.63	+/-0.030	R0.625	✓		"	f.
R1.00	+/-0.030	R1.000	✓		"	i

Measured by:	D.A.	Checked:	
Date:	19-01-12		

Engineering Approval:	
(If necessary)	

Rev	Date	Change	Approved
A	10.06.08	New Issue	
B	11.06.21	Dwg Rev updated	
C	17.07.13	Dimensions updated per Dwg Rev E	KJ